



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18635
Job Sheet 198281



Part No: RBT18635

Job Qty: 1 pcs

Part Name: Tail Rotor Blade Bushing Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18137

Note: DWG RBT18635 Rev 2A IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	9/18/19		0.00	0.10	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	9/18/19		0.00	0.00	QC 5 - 10		DAS 40 SEP 30 2019 9:59
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/18/19		0.00	0.00	QC 5 - 61		
							QC 5 - 81		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S218210



Part: RBT18635

Job No: 198281

Serial No/Batch: S218210

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 09/30/19

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140 QC 21 - FG	1 pcs	9/18/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	9-89
				QC 21 - SA - 53	SEP 30 2019

Part Op 100 - Small Fab - 1-Assemble -5 into -7 using Loctite 680 on bottom threads as per DWG. M 5190057 EXP: 12/31/2020

Descriptions: 2-Bag and tag

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18635-1	Adapter Bushing	1 pcs (1 ea)	100-Small Fab - 1	5 213979
RBT18635-11	Receiver	1 pcs (1 ea)	100-Small Fab - 1	5 214449
RBT18635-3	Spud	1 pcs (1 ea)	100-Small Fab - 1	5 213989
RBT18635-5	Rod	1 pcs (1 ea)	100-Small Fab - 1	5 214862
RBT18635-7	Handle	1 pcs (1 ea)	100-Small Fab - 1	5 214232
RBT18635-9	Spud	1 pcs (1 ea)	100-Small Fab - 1	5 214327

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBT18635-1	1	0	0
	RBT18635-11	1	0	0
	RBT18635-3	1	0	0
	RBT18635-5	1	0	0
	RBT18635-7	1	0	0
	RBT18635-9	1	0	0

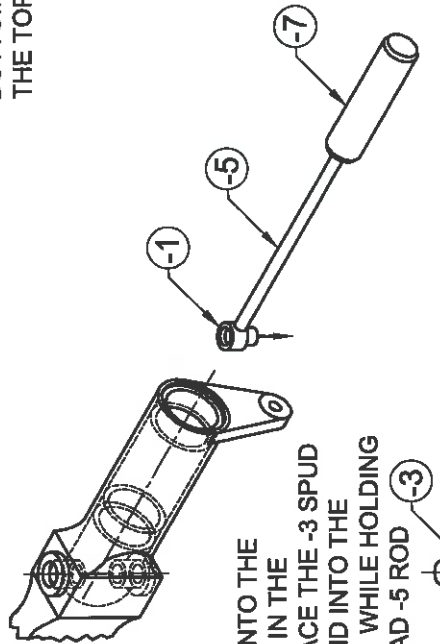
Part Specifications

Specifications could not be found.

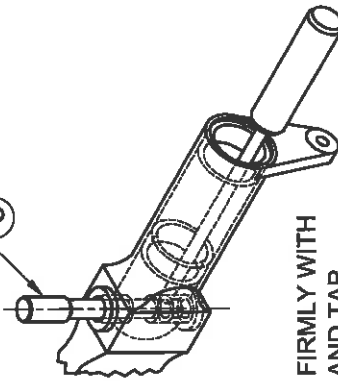
Plex 7/24/19 1:18 PM Dart.lajeunesse.marie

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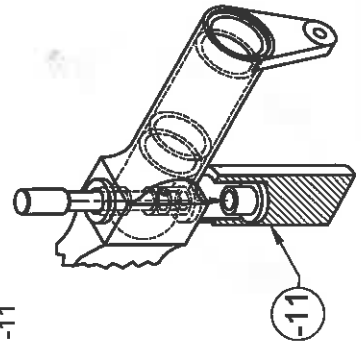
1. THREAD -1 ADAPTER ON TO -5 ROD 1 TO 2 TURNS. HOLD WITH -1 SMALL ROUND PART POINTING DOWN.



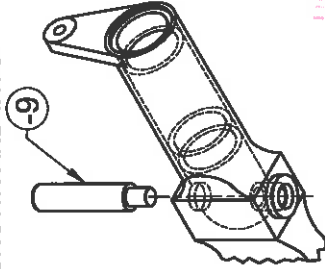
2. PLACE ADAPTER ASSEMBLY INTO THE GRIP WITH THE -1 SOLID ROUND IN THE BOTTOM BUSHING CENTER. PLACE THE -3 SPUD THROUGH THE TOP BUSHING AND INTO THE -1 ADAPTER FIRMLY AS SHOWN. WHILE HOLDING THE ADAPTER FIRMLY, UNTHREAD -5 ROD AND REMOVE.



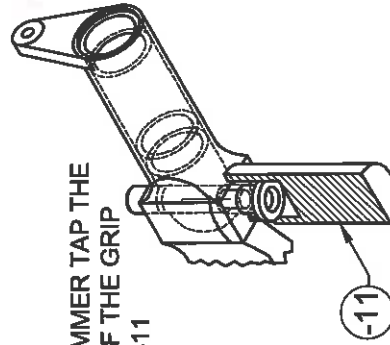
3. WHILE HOLDING -1 ADAPTER FIRMLY WITH -3 SPUD, USE A SMALL HAMMER AND TAP THE BOTTOM BUSHING FREE FROM THE GRIP ASSEMBLY INTO THE -11 BUSHING RECEIVER.



4. ROLL THE BLADE ASSEMBLY 180°. USING THE -9 SPUD, PLACE IT THROUGH THE BOTTOM BUSHING HOLE AS SHOWN AND INTO THE TOP BUSHING.



5. USING A SMALL HAMMER TAP THE TOP BUSHING FREE OF THE GRIP ASSEMBLY INTO THE -11 BUSHING RECEIVER.



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
198781
MCS
1907-24

RED BARN MACHINE
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Eugene, Oregon 97402
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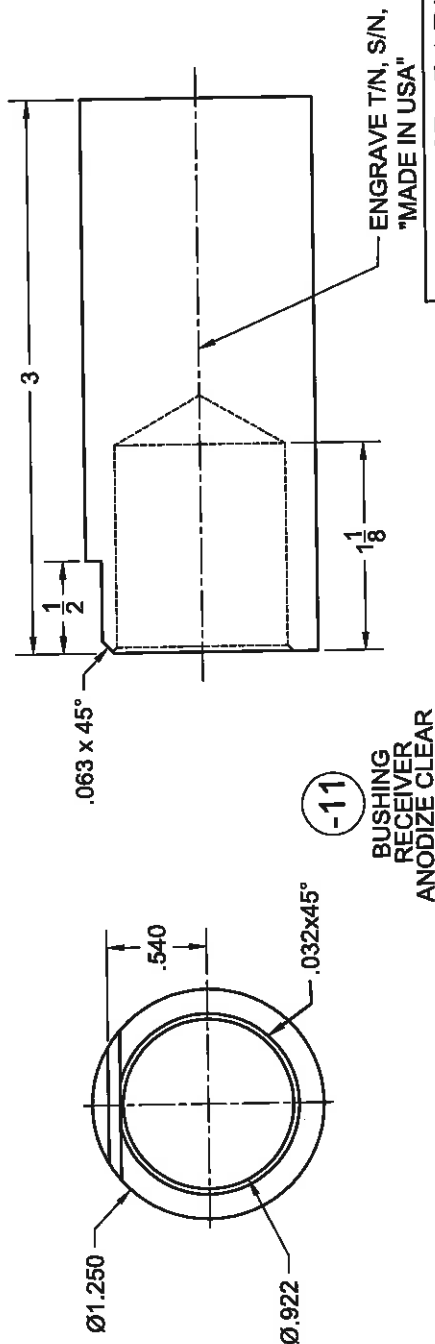
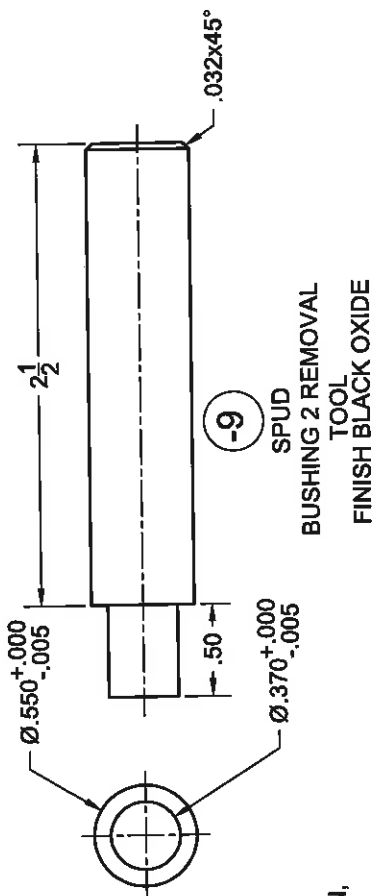
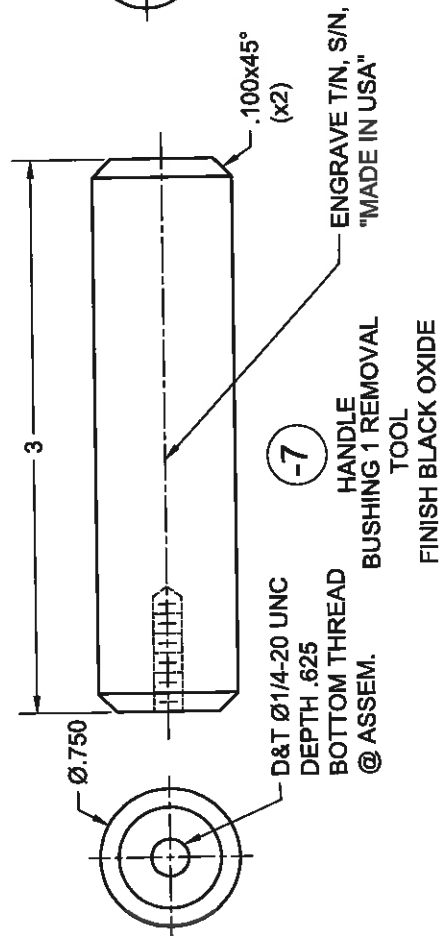
RED BARN MACHINE

TAIL ROTOR BLADE BUSHING REMOVAL TOOL INSTRUCTIONS

RBT18635

SHEET
1 of 1

REV	DESCRIPTION	DATE	INITIAL APPROVED
2	CHANGED -11 R.063 TO CHAMFER & -7 MAT. FROM 101B.	1/13/07	
2A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, CH'D ENGRAVE NOTE -7 & -11.	1/21/10	RJC
			RW



RED BARN MACHINE

TITLE	T/R BLADE BUSHING REMOVAL TOOL
DWG NO.	RBT18635
REV	2A
DRAWN BY:	PERRITT
APPROVED:	<i>P. Perritt</i>
DATE:	
TEST:	
FINISH:	
SPEC:	
USED ON MODEL:	
MD 369D	
MD 369E	
SCALE	NTS
DATE	11-16-06
SHEET	2 of 2



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐
Finishing ☐
Skid-tube ☐
Machining ☐
Large Fab ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By	
Lead hand / Supervisor	
QC / QA Coordinator	

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: